

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	205 SKIDTUBE "I" BEAM
Job Number	:	32218			
Estimate Number	:	10346			
P.O. Number	:	N/A	Part Number	:	D2596
This Issue	:	5/3/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D2596 REV C
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	32098	Drawing Revision	:	C
			Material	:	N/A
Written By	:	<u>[Signature]</u>	Due Date	:	5/10/2007
Checked & Approved By	:	<u>[Signature]</u>			
Comment	:	Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D			

Qty: 5 Um: Each

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n - 1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Extrusion "I" Beam Web 4"

Pick:

Qty	Part Number	Description
1	D2500-3-100	Extrusion

Batch

13 25 151

JD 7-5-9

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

50 7-5-9

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

56 7-5-9

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7-5-9

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

DP

7-5-9

5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 2:32:10 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 32218

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D07105110

Job Completion



U of J. 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

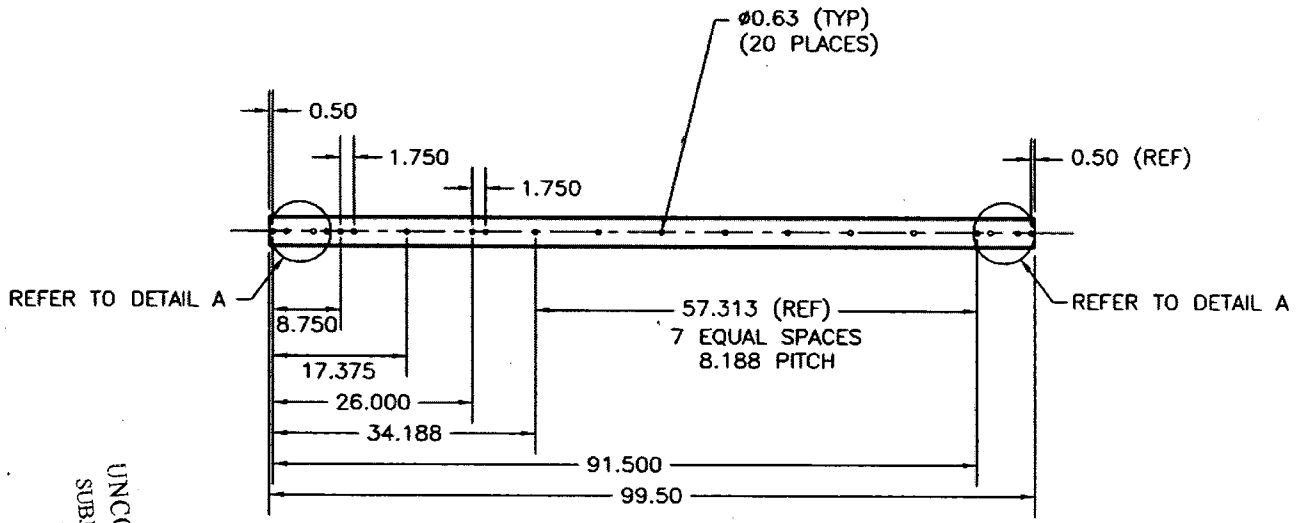
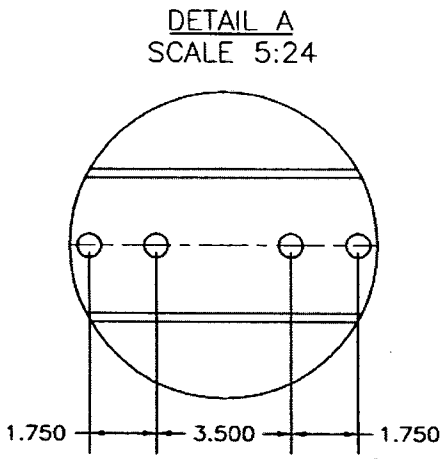
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.09.17 BS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
DATE		D2596	SHEET 1 OF 1	
98.09.14		TITLE	SCALE	
		205 WEB	1:24	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32216